

Date: Tuesday, 03/03/2009 1:00:08 PM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: LOADCELL METER MOUNT
Job Number	: 46238		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D412785001403F
This Issue	: 03/03/2009 S.O. No. :	Drawing Number	: D412-785-001-403
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	:
Previous Run	: 46236	Material	:
Written By	:	Due Date	: 10/03/2009 Qty: 7 Um: Each
Checked & Approved By	:		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

HB 9-3-7

CUT PER DRWG D412-785-001-403 REV.A

DEBURR HB 9-3-7

⑧

2.0	M6061T6S032	6061-T6 Sheet 0.032"
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Comment: Qty.: 0.0550 sf(s)/Unit Total : 0.3850 sf(s)
 6061-T6 Sheet 0.032"

110063

HB 9-3-7

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 9-3-7

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

09-03-11 ⑧

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

MA

ACID ETCH AND ALODINE PER QSI005

09-03-11

⑧

6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

HB 09-03-11 ⑧

Date: Tuesday, 03/03/2009 1:00:08 PM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: LOADCELL METER MOUNT

Job Number: 46238

Part Number: D412785001403F

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
ID AND STK
PUT ASIDE TO SEND TO EAGLE

PU 9/3/12

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/12
[Signature]

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 09-03-12

DART AEROSPACE LTD		Work Order: 46238
Description: LOAD CELL METER MOUNT		Part Number: D 412 785 001 403
Inspection Dwg:	Rev: A	Page 1 of 1

D412 785 001 403

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

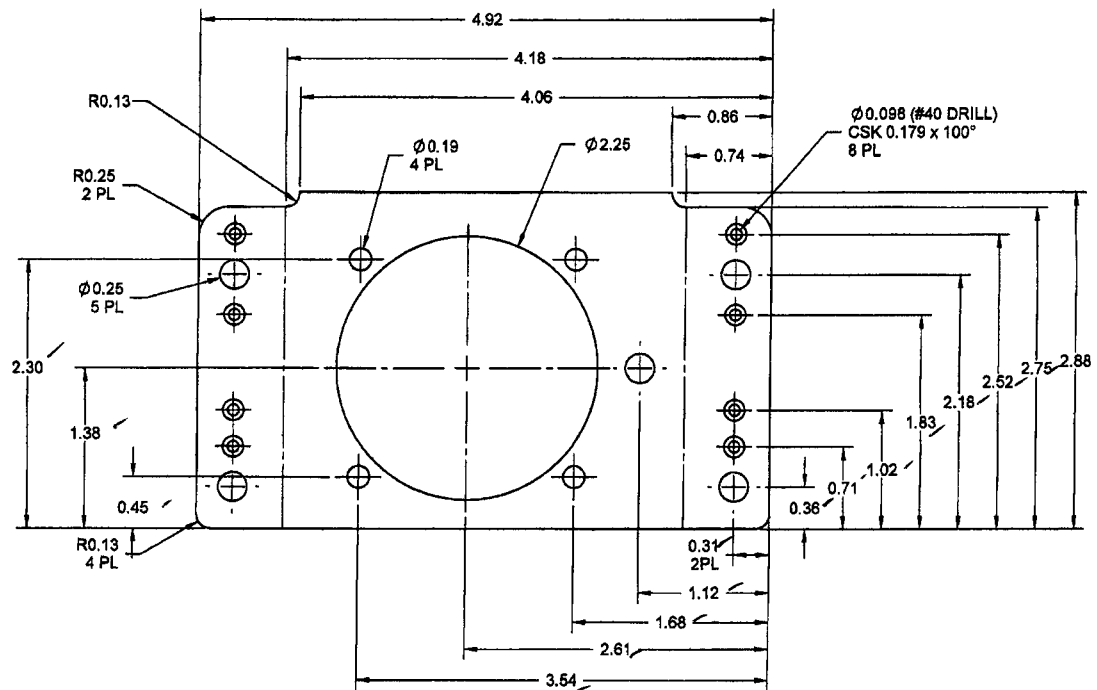
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.101	✗			See e-mail
Ø .19	+ .005 - .001	.193	✗			
Ø .25	+ .005 - .001	.254	✗			
Ø 2.25	+ .012 - .001	2.251	✗			
4.92	± .030	4.922	✗			
4.06	± .030	4.050	✗			
.86	± .030	.860	✗			
2.88	± .030	2.872	✗			
2.75	± .030	2.748	✗			
2.52	± .030	2.515	✗			
2.18	± .030	2.18	✗			
1.83	± .030	1.832	✗			
1.02	± .030	1.021	✗			
.71	± .030	.713	✗			
.36	± .030	.365	✗			
.31	± .030	.309	✗			
1.12	± .030	1.121	✗			
1.68	± .030	1.682	✗			
2.61	± .030	2.605	✗			
3.54	± .030	3.541	✗			
.45	± .030	.448	✗			
1.38	± .030	1.384	✗			
2.30	± .030	2.304	✗			
.032	± .010	.030	✗			

Measured by: RB	Audited by: [Signature]	Prototype Approval:
Date: 9-3-7	Date: 09-03-11	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

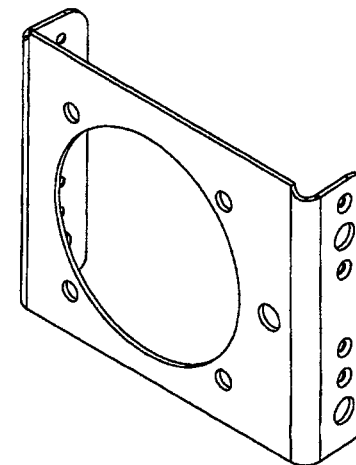
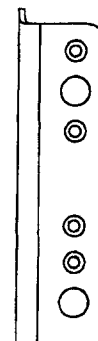
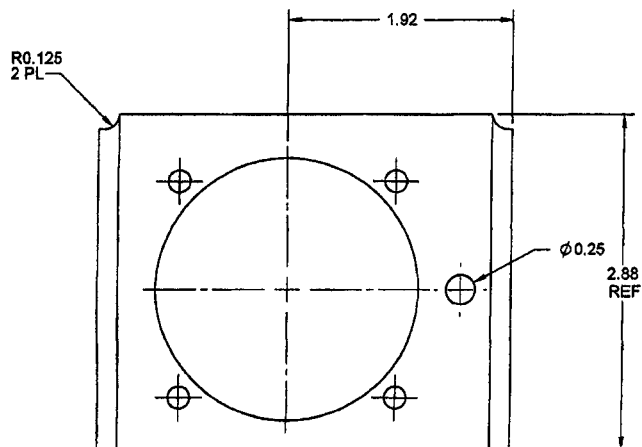
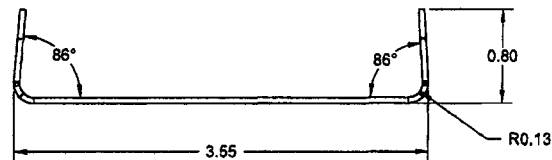
Donk

46238



D412-785-001-403F FLAT PATTERN

DESIGN	RN	EAGLE COPTERS MAINTENANCE	
DRAWN	<i>[Signature]</i>	CALGARY, ALBERTA, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	D412-785-001-403	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	N/A	LOADCELL METER MOUNT	NTS
DATE	08.12.09	<small>COPYRIGHT © 2008 BY EAGLE COPTERS MAINTENANCE THIS DOCUMENT IS PROPRIETARY AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM EAGLE COPTERS MAINTENANCE LTD.</small>	



D412-785-001-403 FACE PLATE
MADE FROM D412-785-001-403F FLAT PATTERN

46238

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6081-T62) ALUMINUM SHEET 0.032 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs

A NEW ISSUE		08.12.09	
REV	DESCRIPTION	BY	DATE
DESIGN	RN		
DRAWN	RN		
CHECKED	RN		
MFG. APPR.	N/A		
APPROVED	RN		
DE APPR.	N/A		
DATE	08.12.09		

EAGLE COPTERS MAINTENANCE
CALGARY, ALBERTA, CANADA

DRAWING NO. **D412-785-001-403** REV. A
SHEET 1 OF 2

TITLE **LOADCELL METER MOUNT** SCALE NTS

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L Lacelle

From: Kelly Labas [klabas@eaglecopters.com]
Sent: March 11, 2009 11:07 AM
To: 'L Lacelle'; 'Harvey Siemens'
Subject: RE: Hawker Parts

Morning Linda,

Go ahead and complete, both items are acceptable.

KL

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Wednesday, March 11, 2009 8:01 AM
To: 'Kelly Labas'; 'Harvey Siemens'
Subject: RE: Hawker Parts
Importance: High

Hi guys,

We cut the D412-785-001-403F, and the .098 holes are oversized by .005 (very thin mat'l for the size of the hole on the waterjet), are these acceptable?

Also for the D412-785-003-401, when you turn these pieces around, none of the holes match up, are these ok? Please advise asap, so we can alodine and ship today.

Thx
Linda

From: Kelly Labas [mailto:klabas@eaglecopters.com]
Sent: March 9, 2009 6:10 PM
To: 'L Lacelle'
Subject: RE: Hawker Parts

Hey Linda,

Do you have date for shipping these parts to us?

KL

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Monday, March 02, 2009 12:09 PM
To: 'Harvey Siemens'
Cc: 'Kelly Labas'; 'Crystal Benoit'
Subject: RE: Hawker Parts

Whoa.....I thought these were just waterjet parts? These look more complicated than that!

From: Harvey Siemens [mailto:hsiemens@dartaero.com]
Sent: March 2, 2009 2:03 PM
To: 'L Lacelle'
Cc: Kelly Labas; 'Crystal Benoit'

11/03/2009

Subject: Hawker Parts

Linda

Please find attached the dwgs and DXF for the sheet metal parts that Eagle needs. I expect that Crystal (or someone else from purchasing) will be getting you a PO showing quantities etc.

I realize that these drawings have not been signed off by anybody over there. Hopefully they will still be OK.

Let me know if there is anything else that you need.

Regards,

Harvey Siemens

Mechanical Designer
DART Aerospace Ltd.

P: 403-717-0328

F: 403-717-1288

E: hsiemens@dartaero.com

W: www.dartaero.com

M: 1060 McTavish Road NE, Calgary, Alberta, T2E 5G9

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11/03/2009